

Work Order ID 57192

March 29, 2010 9:16:59 AM



Page 1

Item ID: D3267-041

Accept



Setup Start



Revision ID:

Item Name: Basket lid Assembly (Outside)

Stop



Start Date: 05/04/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 07/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: *16-3-79*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3267

Rev C

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *1111679*

0.00

Large Fab

Memo

0.00

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-041 as per Dwg D3267

4-Deburr & Remove All Markings From Material

SAD 10.03.31

5-Weld D3267-041 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

6-Drill Ø0.257" hole in D3267-041 as per Dwg D3267 Identify as D3267-041

SPC 10.04.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 10.04.04

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S 106464

⑩

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

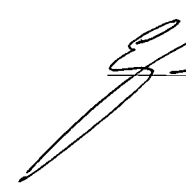


QC

Memo

0.00

Quality Control

 5/10/04/00

155

Identify as per dwg & Stock Location: GA

0.00

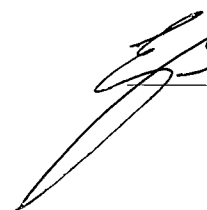


Packaging

5/10/04/00
Memo

0.00

Packaging

 5/10/04/00

160

QC21- Final Inspection - Work Order Release

0.00

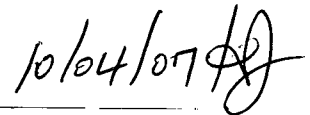


QC

Memo

0.00

Quality Control

 10/04/07UMF
10-4-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

March 29, 2010 9:17:03 AM

Page 1

Work Order ID: 57192

Parent Item: D3267-041

Parent Item Name: Basket lid Assembly (Outside)



Start Date: 05/04/2010

Required Date: 07/04/2010

Comments: IPP Rev:C Removed -043 05-11-04 JLM
 IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified
 by:EC IPP Rev:E add I.D. DD 10.03.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2327-3		Manufactured	No			100	Each	28.0000	2.0000			
												
Spacer Bushing												

Pl 10.03.31

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA	28
44274	4
44365	9
55917	15

D2506



Label Plate

Manufactured No

100 Each 6.0000 1.0000



2

Pl 10.03.31

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA	6
44275	1
55700	5

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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March 29, 2010 9:17:03 AM

Page 2

Work Order ID: 57192



Parent Item: D3267-041

Parent Item Name: Basket lid Assembly (Outside)

Start Date: 05/04/2010

Required Date: 07/04/2010

Comments: IPP Rev:C Removed -043 05-11-04 JLM
 IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified
 by:EC IPP Rev:E add I.D. DD 10.03.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ D2581	Replacement	Mfg/ Manufactured	Bin No	Primary	Last	Route 100	Unit of Each	Qty on 35.0000	Remaining 2.0000	Qty	Date	Status
✓											<i>Pl 10-03-31</i>	
Mounting Bracket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA	35	
46086	2	
48428	1	
50872	1	
51120	2	
51745	2	
55918	27	

2

D3166-3 Manufactured No

100 Each 16.8103 1.0000



Basket Hoop



SAD 10-03-31

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA	16.81031447	
48429	5	
52058	1.4474E-05	
55697	5.8103	
56426	6	

LOGO

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 3

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Required Date: 07/04/2010

Comments: IPP Rev:C Removed -043 05-11-04 JLM
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified
by:EC IPP Rev:E add I.D. DD 10.03.11 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304EX0.75-16F		Purchased	No			100	sf	1,081.944	8.2105			
Expanded Metal Flat SS												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

1081.944806

111956

0.000017

112147

9.4736E-06

112949

19.84438

113205

0.0093

113497

0.1449

113555

649.5873

113904

92.3589

114212

320

M304TS0.750W.065

Purchased

No

100

f

638.1112

32.2105



304 SQ Tube .75x.75x.065W

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

638.111759

112398

0.0000047

113082

0.00419

113245

8.40038421

113683

0.30855

113836

0.000047

113956

29.398

114137

600

March 29, 2010 9:17:03 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 51192

PH 10-3-21

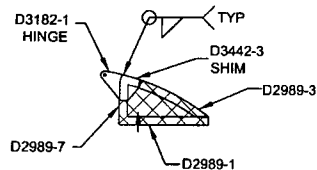
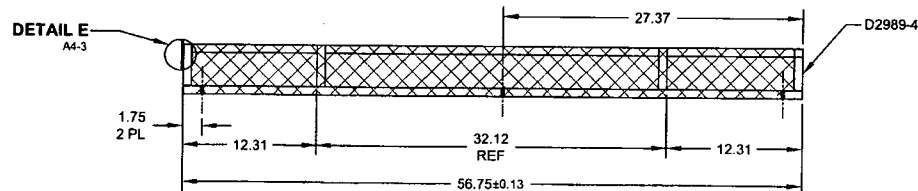
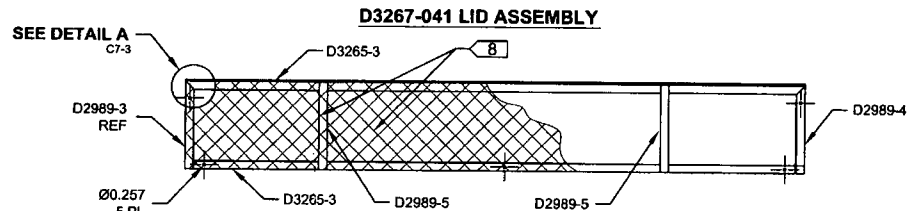
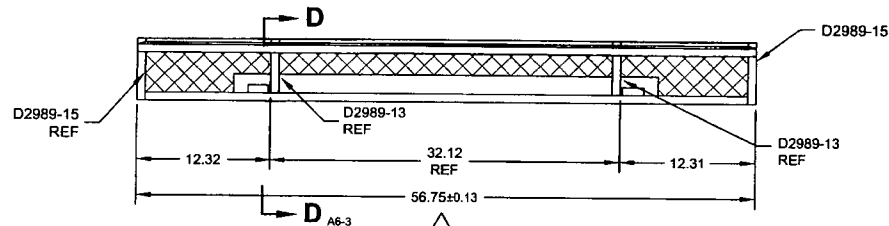
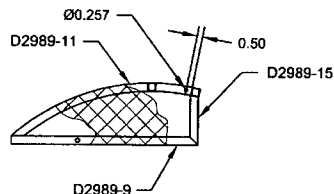
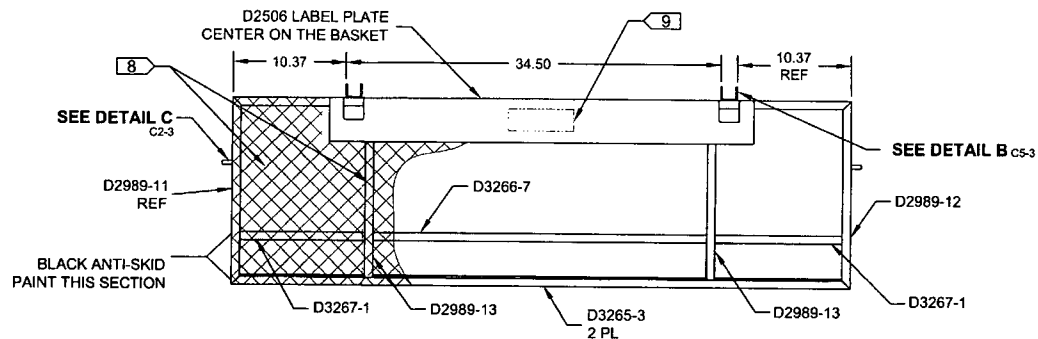
RELEASED
08-09-14



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3267	SHEET 1 OF 3
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	BASKET LID ASSEMBLY	NTS
DATE	08.08.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	





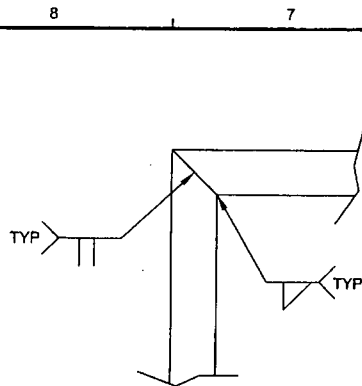
NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

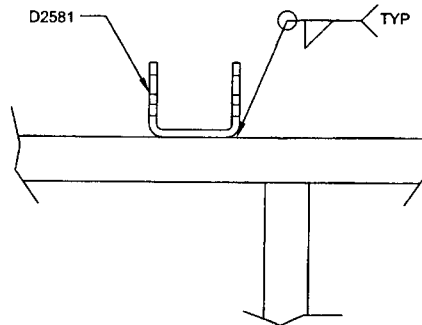
W/O 57192

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08-07-04/10

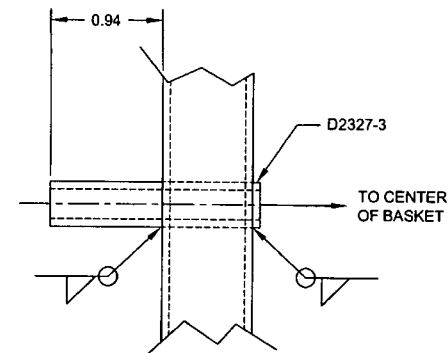
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DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	2 OF 3
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DE APPR.		BASKET LID ASSEMBLY	NT
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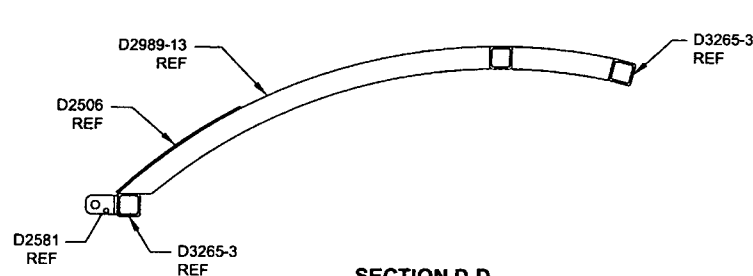
DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X



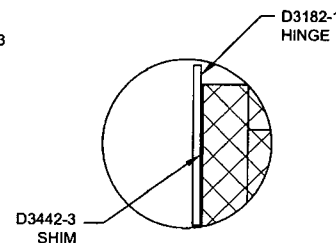
DETAIL B D2-2
2 PL
SCALE 2X



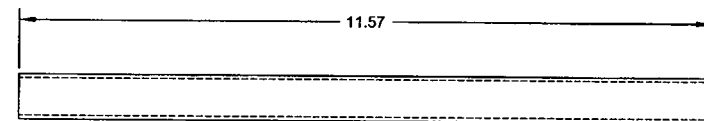
DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X



SECTION D-D C4-2







DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

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08.07.1992

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DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSMBLY	NTS
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